

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000033**Date Inspected:** 06-Dec-2006**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** N/A**Summary of Items Observed:**

Office of Structural Materials Quality Assurance Inspector (QA), Mark Wright was present as requested to observe quality control functions related to procedure qualification record (PQR) testing at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA Inspector did not observe welding on this date, but was asked to review radiographic film for PQR 2006119-2. The film had been previously rejected by the Quality Control department. The QA concurred with the QC's assessment of the film.

The QC department spent the rest of the day witnessing flux core arc welding for practice on PQR 2006107-3 which has had lack of fusion at the root area on previous three attempts and recorded on TL6031s on prior dates.

**Summary of Conversations:**

The QC Inspector with ZPMC Quality Control (QC) stated the RT film for PQR HP-2006119-2 would be rejected by QC due to porosities located throughout the weld metal. The Caltrans Quality Assurance Inspector was asked to review the film for a second opinion. The QA stated that the film would have been rejected by the QA for porosity.

The QC Inspector with ZPMC Quality Control stated that they would be running practice plates for the PQR 2006107. The QC stated that the weld cap was ground smooth and the weld was found not to comply due to lack of fusion in the root area.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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## WELDING INSPECTION REPORT

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remedial efforts please contact Mazen Wahbeh, (818) 292-0659,, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wright,Mark	Quality Assurance Inspector
<b>Reviewed By:</b>	McClary,David	QA Reviewer

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